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RBE703A95-0520-01
Job Sheet 189804



Deviation

Part No: RBE703A95-0520-01

Job Qty: 3 pcs *12 DAS 21*

Part Name: Engine And Hydraulic Drain Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/30/19

Job Tracking No:

Due Date: 3/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A95-0520-01 Rev 4 IPP Rev A 18.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	3 pcs	3/15/19		1.00	0.20	Small Fab - 1		
							Small Fab - 2		<i>MLL</i>
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	3 pcs	3/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		<i>DAS 40 DAS 9-89 9-30</i>
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	3 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S155296



Part: RBE703A95-0520-01

Job No: 189804

Serial No/Batch: S155296

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 02/21/19

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MLC
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAG
140 QC 21 - FG	3 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21	21	MAR 05 2019
					QC 21 - FG - 70	

Part Op 100 - 1-Assemble -9 coupling with -7 hose. 2-Bag and tag. Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel
 Descriptions: into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before
 placing tool into packaging (if applicable).

110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____), Identify and Stock

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
51495K116	COUPLING 1/2" NCKL PLTD BRASS	3 Ea (1 ea)	100-Small Fab - 1	5147991
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	18 ft (6 ea)	100-Small Fab - 1	5152493
M304TR0.375W.065	304 Round Tube .375 X .065W	.2490 ft (.083 ea)	100-Small Fab - 1	5145223
RBE703A95-0520-01-1	Quill	3 pcs (1 ea)	100-Small Fab - 1	5150361

Job Allocations

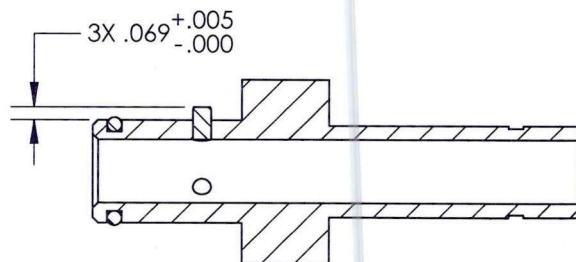
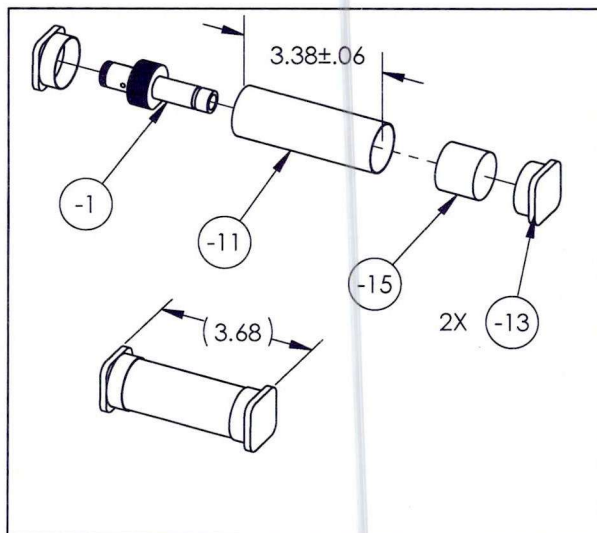
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	51495K116	3	70	0
	K010-0608	18	455	0
	M304TR0.375W.065	0	60	0
	RBE703A95-0520-01-1	3	0	0

Part Specifications

Specifications could not be found.

Plex 1/30/19 1:36 PM Dart.lajeunesse.marie

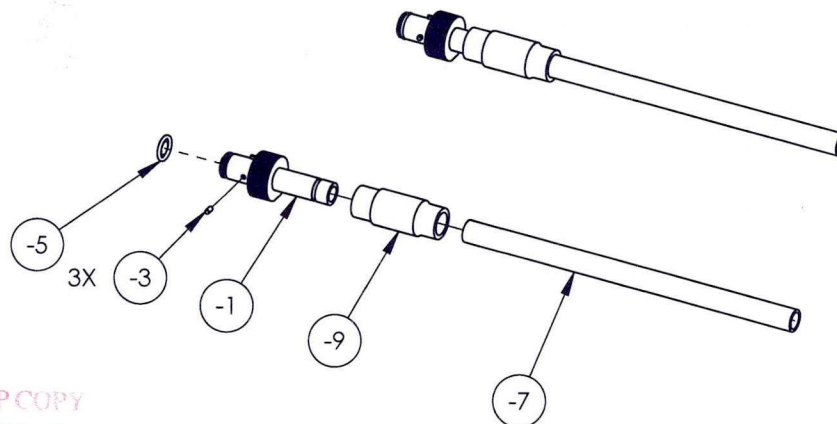
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-1 PRESS DETAIL
SCALE 1 : 1

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SECOND FLAT TO ENGRAVE S/N & "MADE IN USA", ADDED NOTE TO DETAIL.	5/22/2009	RJC	
2		CH'D P/N -1 MATERIAL FROM STRESS PROOF & FINISH SPEC TO RED ANODIZE PER WP & DW , ADDED MIL SPEC PER WP.	10/29/2009	RJC	RW
3		MODIFIED -1 TO WORK WITH COUPLING, ADDED COUPLING, DELETED HOSE CLAMP. CH'D HOSE FROM Ø 5/8 TO Ø 1/2, ADDED TUBE, CAPS, & SPONGE	7/31/2012	JAG	
3A		CH'D T/N WAS RBEA95-0520-01 IS RBE703A95-0520-01.	6/19/2013	BIM	RW
3B		CH'D TOOL NAME WAS POWERPLANT & HYDRAULIC RESERVOIR DRAIN TOOL IS ENGINE & HYDRAULIC DRAIN TUBE.	11/7/2013	RJC	RW
3C		-11 CH'D DIM WAS 3.48 IS 3.38. -15 CH'D MATERIAL TO NEW PIG CORP. #PAD210.	2/5/2014	DPD	RW
3D		-7 CH'D LENGTH OF HOSE WAS 6 FEET IS 7 FEET.	3/26/2014	RJC	DW
4	14-0209	CH'D TITLEBLOCK WAS RED BARN IS DART. -1 REMOVED .059 LIP FROM INPUT SIDE OF QUILL. CH'D DIM WAS Ø1.00 IS (Ø1.00). DELETED DIM 3X .591. ADDED DIM 3X .216. CH'D B/O INFO WAS Ø3/4 X 2-7/8 IS Ø1 X 2-7/8.	11/4/2014	DPD	JAG

SEE ATTACHED DEVIATION



SHOP COPY
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SUBJECT TO AN ENDORSEMENT
WITHOUT NOTICE
WORK ORDER
NO. 189804 MJS
1901-30

FUNCTION: USED TO DRAIN OIL SYSTEMS; ARRIEL
POWER PLANT & HYDRAULIC RESERVOIR.

ORIGINAL No. REFERENCE
RBEA95-0520-01 = 703A95-0520-01 = E-350-2 = 881218700

DART AEROSPACE	
TITLE ENGINE & HYDRAULIC DRAIN TUBE	
DWG NO. RBE703A95-0520-01	REV 4
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL EUROCOPTER AS350A
SCALE 1:4	DATE 11/10/2008 SHEET 1 OF 2

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061	Ø1 X 2-7/8	2
		B/O	-3	3	DOWEL PIN	S.S.	Ø2.5mm x 6mm MCMaster-CARR #91585A030	1
		B/O	-5	1	O-RING	VITON	Ø15mm OD x 2mm WIDTH MCMaster-CARR #9263K519	1
		B/O	-7	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-9	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMaster-CARR #51495K116	1
		B/O	-11	1	TUBE	POLYETHYLENE	Ø1.09 MCMaster-CARR #2044T47	1
		B/O	-13	2	CAP	VINYL	Ø1.09 MCMaster-CARR #2044T67	1
		B/O	-15	1	FOAM	POLYESTER/POLYURETHANE	Ø1 X 1 NEW PIG CORP. #PAD210	1



Route update only

7

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J